

Work Order ID 70063

Thursday, May 26, 2011 9:11:32 AM



Page 1

Item ID: D3749-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half

Start Date: 5/26/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: M

Date: 11-05-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3749

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3749

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Deburr if necessary

B11-5-27

(18)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 mcs/30

(18)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 6/6/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(18)			
Brake NC	Memo Form as per Dwg D3749 using CNC Brake	0.00							
			SAD 11-06-03						
140 QC	QC5- Inspect part completeness to step on W/O	0.00				(18)			
Quality Control	Memo	0.00							
			SAD 11-06-03						
150 Packaging	Identify as per dwg & Stock Location: <u>WA</u>	0.00				(18)			
Packaging	Memo *****STOCK IN BASKET CELL*****	0.00							
			SAD 11-06-03						

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Page 3

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Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/78
MK

11-06-03

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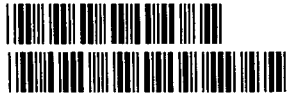
NOTE: Date & initial all entries

Picklist Print

Thursday, May 26, 2011 9:11:38 AM

Page 1

Work Order ID: 70063



Parent Item: D3749-1

Parent Item Name: Hinge Half



Start Date: 5/26/2011

Required Date: 6/6/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-02-05 new issue DD verified by:EC
IPP Rev B 08-02-27 rev.A as per ecn 1139 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	137.2000	0.0187	0.236211	15		
										B11-5-37			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					MAT020	137.2							
					117494	137.2							
									117494	(18)			

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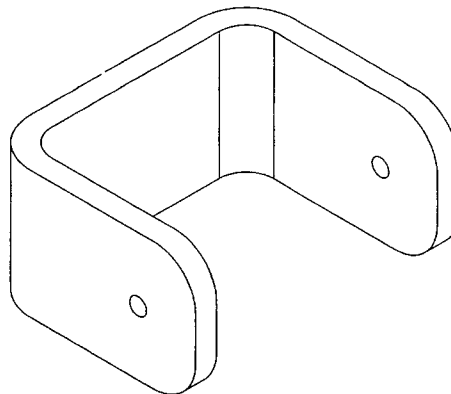
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D3749-1 HINGE HALF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70063

PL 11-05-26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

16 08.02.25

A		NEW ISSUE		AJS	08.02.01
REV.		DESCRIPTION		BY	DATE
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		ASS			
CHECKED		KE		DRAWING NO.	REV. A
MFG. APPR.		[Signature]		D3749	SHEET 1 OF 2
APPROVED		[Signature]		TITLE	SCALE
DE APPR.		[Signature]		HINGE HALF	NTS
DATE		08.02.01		COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

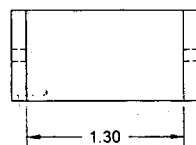
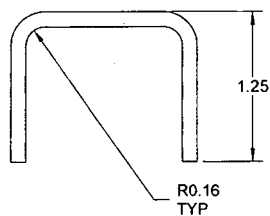
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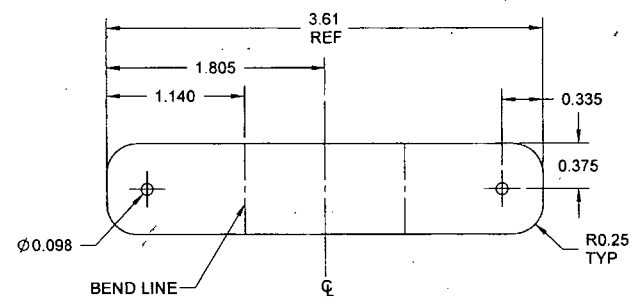
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D3749-1 HINGE HALF



D3749-1F FLAT PATTERN

w/o 70063

16.08.02.25

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	<i>AJS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>KE</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MA</i>	D3749	SHEET 2 OF 2
APPROVED	<i>MA</i>	TITLE	SCALE
DE APPR.	<i>MA</i>	HINGE HALF	2:1
DATE	08.02.01	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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